

Work Order ID 164341

164341

Page 1

Wednesday, July 19, 2017 11:09:10 AM

Item ID: D5149-7TRN

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Step Base Turning Detail

Start Date: 7/18/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/24/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 19 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5149	D

100	MORI SEIKI CNC LATHE LARGE	0.00							DAS 33 9-89 17/07/14
100						4	1		
Doosan	Memo	1.51							
Doosan Lathe	Turn blank as per Folio FB356								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 33 9-89 17/07/14
110						4	1		
QC	Memo	0.04							
Quality Control									

120	QC8- Inspect parts - second check	0.00							DAS 49 9-89 17/07/20
120						4	0		
QC	Memo	0.08							
Quality Control									

NCR →

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>114341</u> Part No. <u>5149-7</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☒</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>				Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☒	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐																																																																																																		
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Date: <u>17/07/24</u>		Step #: <u>100</u>		QTY Effective: <u>1</u>		MRB (QS1042) Approval <u>S 11/07/26</u>																																																																																																																																	
Description Work Order Deviation Part as Mark's of vibration and ID and OD are not centered centered! R-C → Part Move while Machining				Disposition SCRAP and Replace M137043 <u>0.425'</u>				Completed By 33 9-89 <u>17/07/24</u> Lead hand / Supervisor Approval Verification <u>mf</u> <u>17/07/24</u> QC / QA Coordinator DAS Approval 38 9-89 <u>JUL 26 2017</u>																																																																																																																															
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Work Order ID 164341

Wednesday, July 19, 2017 11:09:10 AM

164341

Page 2

Item ID: D5149-7TRN

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Step Base Turning Detail

Start Date: 7/18/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/24/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					41	0		DAS 49 9-89
Packaging	Memo	0.04							17/07/26
Packaging	LOCATION: MAT060								
140		0.00							
140	QC21- Final Inspection - Work Order Release								17/7/26
QC	Memo	0.40							
Quality Control									

41
7/26/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
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Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Wednesday, July 19, 2017 11:09:16 AM

Page 1

Work Order ID: 164341

164341

Parent Item: D5149-7TRN

D5149-7TRN

Parent Item Name: Aft Step Base Turning Detail

Start Date: 7/18/2017

Required Date: 7/24/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 14-12-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6R3.250

Purchased

No

100

f

11.4600

0.416

1.664

DAS

33

9-89

17/07/24

M6061T6R3 250

**

6061-T6 RD BAR 3.250"

Location

Loc Qty

Loc Code

MAT013

11.46

m137043

11.46

1,7'

DQA: _____ Date: _____

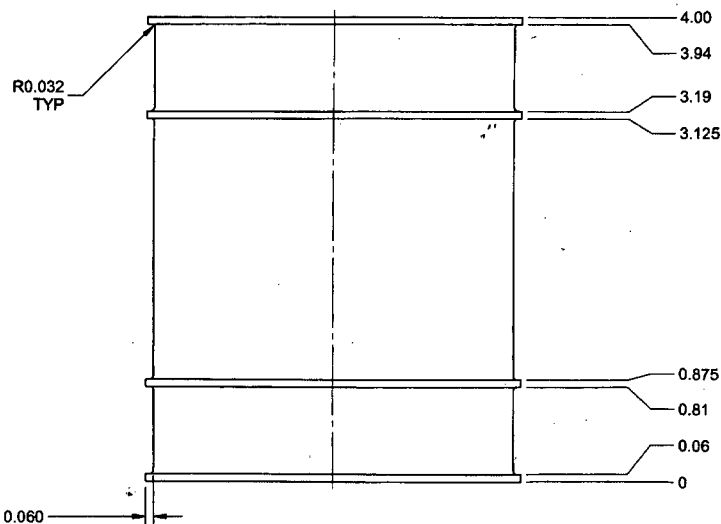
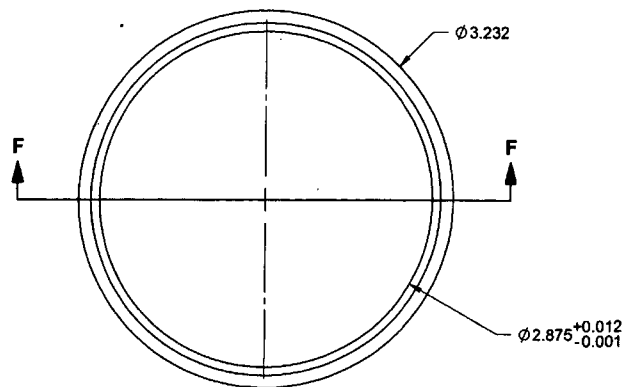


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

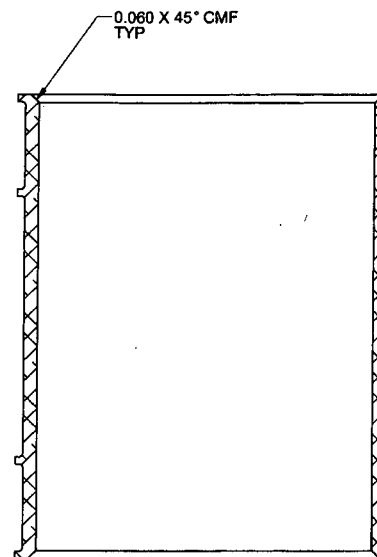
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



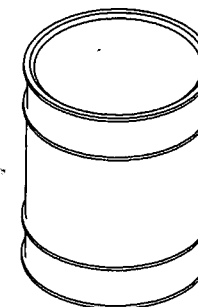
D5149-7TRN TURNING DETAIL

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.41 lbs



SECTION F-F



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *1643011 MJS*
170779

RELEASED
2015-11-04

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DD	D5149	SHEET 10 OF 11
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
DATE	15.10.20	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	